

Date: Monday, 6/5/2006 8:59:37 AM
 User: Linda Lacelle

Process Sheet

SP1.17
 06-06-13
 PTO

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHORT STEP ASSEMBLY
 Job Number : 27396
 Estimate Number : 11999
 P.O. Number : N/A Part Number : D350591122
 This Issue : 6/5/2006 S.O. No. : N/A Drawing Number : D2351 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : E
 Previous Run : 25537 Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 6/27/2006 Qty: 6 Um: Each
 Checked & Approved By :
 Comment : Est Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP K
 J/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-122 CHG003

KS 06.06-20

2.0 D2244116 Step Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch
 0.5 D2244-128 Extrusion 323404

PE. 06.06.5

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244-128 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

PE. 06.06.5 6

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

PE. 06.06.5 6

3-Deburr

PE. 06.06.5 6

4.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

Bend per Dwg D2351 using Bend Program D2351.2D

DP 06-6-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BF 06-06-09 6

6.0	D28502	End Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2850-2	End Bracket	B9907
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LE 06-06-09 6

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Fwd and Aft end for welding

2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033

A/R Aluminum Rod 19173

3-Do not Grind Flush

LE 06-06-09 6

LE 06-06-09 6

LE 06-06-09 6

SP17

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06/06/14

3

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 06.06.15 3

10.0	D2582	Hi-Skid Step Leg Ass'y
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2582	Step Leg Assy	B25395
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LE 06-06-15 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-06-13	7.1	QC S/S Inspect work i weld.	<i>[Signature]</i>	06-06-13	3	<i>[Signature]</i> 06-05-06	<i>[Signature]</i> 06-06-13	
		Add to estimate permanent change <i>[Signature]</i>		06/06/13	3			
06-06-13	7.1	Split w/o for 3 parts. 3 don't fit well and waiting for response.	<i>[Signature]</i>	06-06-13	3		<i>[Signature]</i> 06-06-13	

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Job Number: 27396

Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W3 Rivet

M13767 - *10/11*

J.E. 06-06-22 3

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet Leg Assembly as per Dwg D2351

J.E. 06-06-22 3

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

B.E. 06-06-22 (3)

14.0

D267334

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2673-34 End Plate

B25369

J.E. 06-06-22 3

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd End Plate per QSI 004 & Dwg D2351

A/R

Aluminum Rod M15689

J.E. 06-06-22 3

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/06/22 (3)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

PL 06/06/25 (3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-06-13	16	Add QC 9 to QC 5 permanent change						
06-06-15	15a	grind end plate flush as per dwg. Add to estimate. permanent change	ll.	06-06-22 06-06-22	30	06-07-06	06-06-13 06-06-22	

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Job Number: 27396

Part Number: D350591122

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m. 06-06-29

(3)

19.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Wing Walk per Dwg D2351 and QSI 005 4.4

Batch: *1101266*

1101266

(3)

20.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m. 06-07-04

(3)

21.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

22.0	D22301	Mounting Lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Packing Kit	Qty	Part Number	Description	Batch
1	D2230-1	Mounting Lug	<i>B23724B</i>	

23.0	D22303	Mounting Lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Packing Kit	Qty	Part Number	Description	Batch
1	D2230-3	Mounting Lug	<i>B26893</i>	

24.0	D2856400	Abrasion Strip
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Comment: Qty.: 0.6000 f(s)/Unit Total : 3.6000 f(s)

Pick:

Packing Kit	Qty	Part Number	Description	Batch
1	D2856-400	7.20" Abrasion Strip	<i>B25656</i>	

600

W/O:		WORK ORDER CHANGES					
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Part Number: D350591122

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	AN337A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

2 AN3-37A Bolt M13719

26.0	AN413A	Bolt
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

3 AN4-13a Bolt M101149

27.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

4 AN960JD10 Washer M100743

28.0	AN960JD416	Washer
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

6 AN960JD416 Washer M100575

29.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

2 MS21042L3 Nut (or -3) M100393

30.0	MS21042L4	Nut
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

3 MS21042L4 Nut (or -4) M10019085

(3) Rec'd 6/6/28

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Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 07/05/06

(3)

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-122

Location: C

PPP Rev: 7/5

06/7/05

(3)

33.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

06/07/06

(3)

Job Completion



u 06-07-05

W/O:		WORK ORDER CHANGES					
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